

Date: Thursday, 01/05/2008 9:46:01 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 38925		
Estimate Number	: 10383		
P.O. Number	:	Part Number	: D30661
This Issue	: 01/05/2008 S.O. No. :	Drawing Number	: D3066 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 38150	Material	:
Written By	:	Due Date	: 07/05/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>JLD 08-5-01</u>		
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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MAT NOT PULLED



Comment: Qty.: 0.0992 sf(s)/Unit Total: 9.9225 sf(s)

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: 107711x61 HB 8-5-6107276x

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev: BProg Rev: B

HB 8-5-6

(103)

2-Deburr if necessary HB 8-5-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-5-6



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/05/06

(103)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-05-07

(103)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:46:01 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 38925

Part Number: D30661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



103x

Comment: INSPECT CHEMICAL CONVERSION COAT

M-F 08/05/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WPH

08-05-08 103

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF . 08-05-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

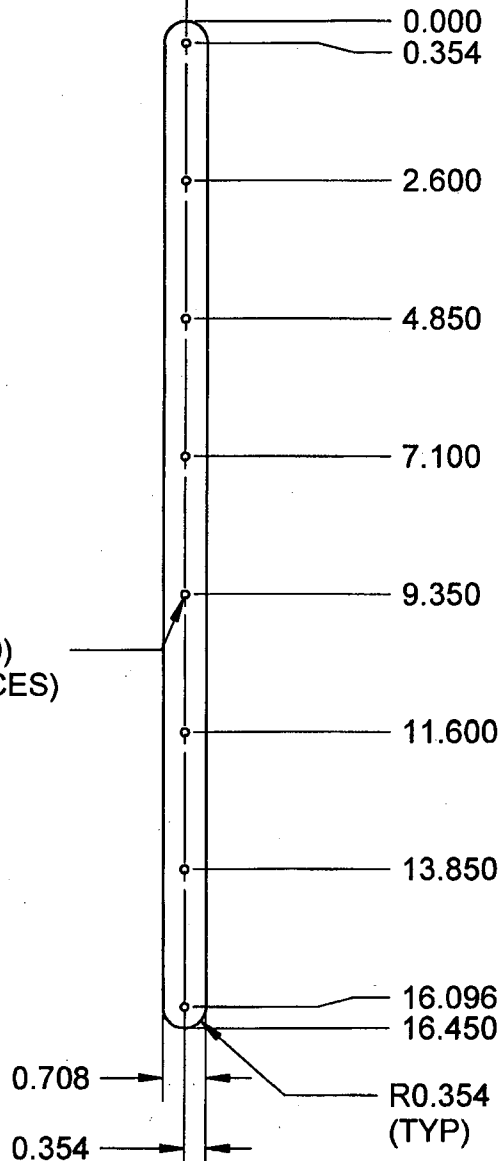
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED*de.de.20*

$\phi 0.128$ (#30)
(TYP 8 PLACES)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38925

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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